

Date: Monday, 9/10/2007 1:18:58 PM  
User: Kim Johnston

## Process Sheet

Split 3

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34475  
Estimate Number : 12882  
P.O. Number : N/A  
This Issue : 9/10/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL / MED FAB  
Previous Run : 32645

Drawing Name : ARM

Part Number : D3560042  
Drawing Number : D3560 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : BC  
Material : Alux  
Due Date : 9/17/2007

Qty: 12 Um: Each

Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07.05.24 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total : 17.5770 f(s)  
6061-T6 Bar 0.50" x 5.00"  
Batch: M105646

JL 07/09/20 (12)

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut blanks 16.750" long

JL 07/09/20 (12)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev. AA & Dwg D3560 Rev. C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

JL 07/09/21

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 07/09/21

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 07/09/21 (12)

2





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34475

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



\* Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

334220 334478 (3)

07-10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07-10-29 (3) 07-10-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/29 (3042)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-29 (3)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FA 07/10/01 (3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/10/29

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-01 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: MA

07-11-01 (3)

THE UNIVERSITY OF CHICAGO

LIBRARY OF THE UNIVERSITY OF CHICAGO  
1215 EAST 58TH STREET  
CHICAGO, ILL. 60637  
TEL. 773-936-5000  
FAX 773-936-5001  
WWW.CHICAGO.EDU

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34475

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 9/14/07*

Job Completion



*Handwritten: U of 11.02*



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DART AEROSPACE LTD		Work Order:	34475
Description: Arm		Part Number:	D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

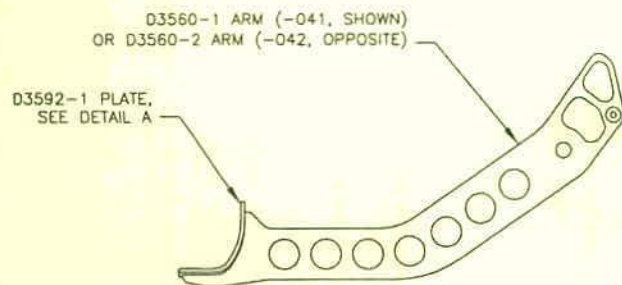
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5063	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.004	✓			
0.500	+/-0.010	.495	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.276	✓			
0.188	+/-0.010	.192	✓			
2.000	+/-0.010	2.001	✓			
1.700	+/-0.010	1.700	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.385 x 100°	✓			
0.250 Deep	+/-0.010	.250	✓			

Measured by: <u>SL</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>07/07/21</u>	Date: <u>07/07/21</u>	Date:	N/A

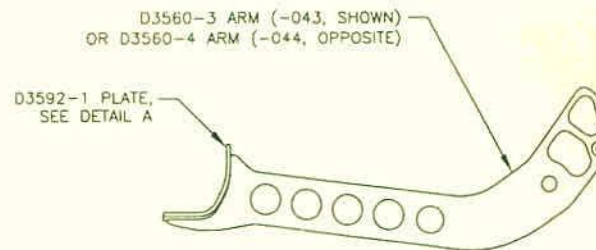
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <u>[Signature]</u>	<u>[Signature]</u>



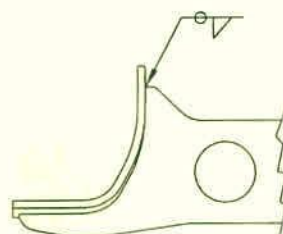
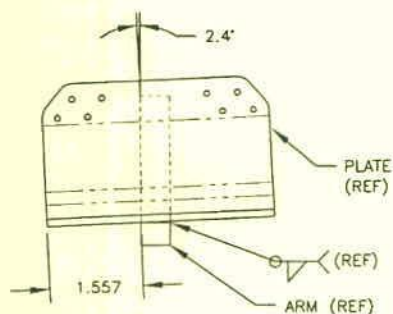




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

#### GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19

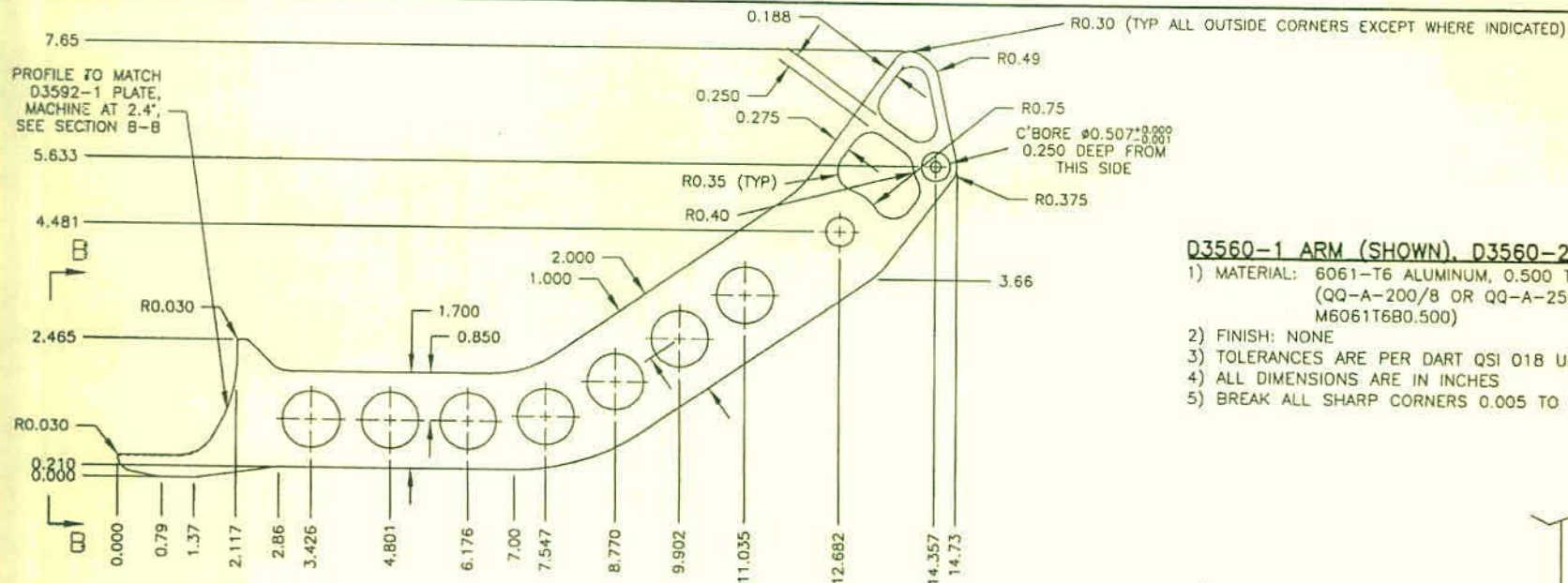
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	th	APPROVED th
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

NO. 3447  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

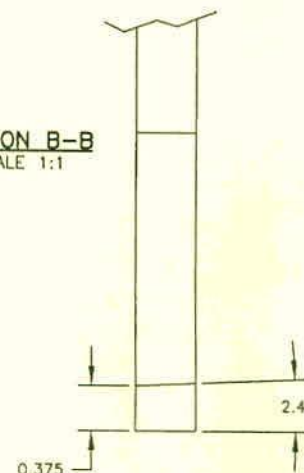




### D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

### SECTION B-B SCALE 1:1



RELEASED  
07.06.19

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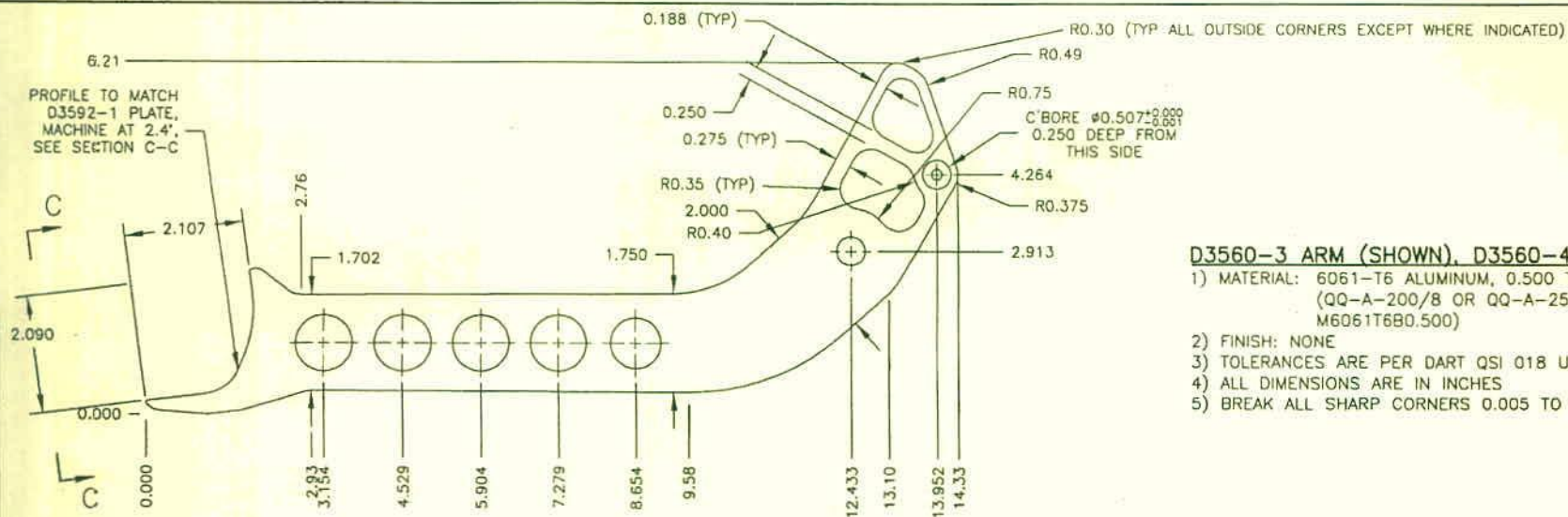
DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560	REV. C SHEET 2 OF 3
DATE 07.06.19	TITLE ARM WELDMENT	SCALE 1:2	

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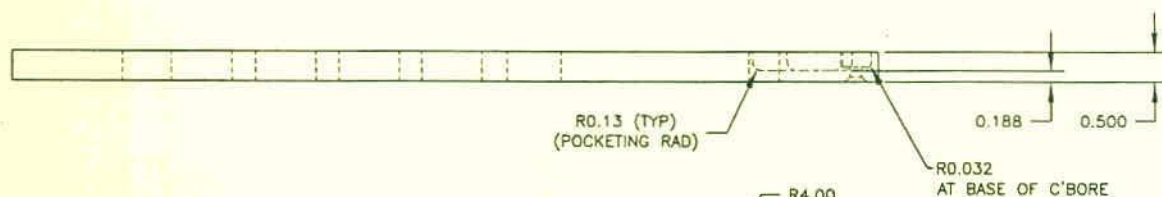


PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4",  
SEE SECTION C-C

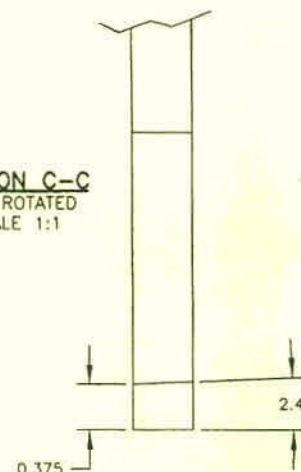


### D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.  
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

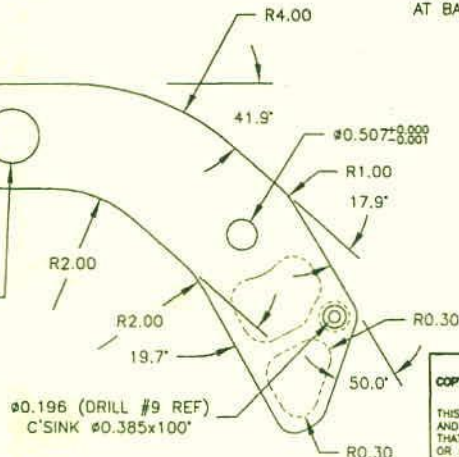


### SECTION C-C VIEW ROTATED SCALE 1:1



**RELEASED**  
07.06.19

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DART AEROSPACE LTD.

DESIGN	49	DRAWN BY	49	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	49	APPROVED	49	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2

